

Date: Tuesday, 4/18/2006 1:05:24 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VALVE SEAL
Job Number : 26712	
Estimate Number : 12207	
P.O. Number : N/A	Part Number : D34707
This Issue : 4/18/2006 S.O. No. : N/A	Drawing Number : D3470 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26266	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 4/25/2006 Qty: 10 Um: Each
Checked & Approved By : <u>CJOG104/18</u>	
Comment : Est Rev: A New Issue 06-02-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MSIL60S125	high temp. silicone sheet .125
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Comment: Qty.: 0.0648 sf(s)/Unit Total : 0.6479 sf(s)

Material: 125 Thick High Temp Silicone sheet

(M-SIL60S.125)

Batch: B26473

SB 06/04/19 (10)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Fabricate as per Dwg D3470

SB 06/04/19 (10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BOC 04.24 (10)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

BOC 04.27 (10)

5.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/04/28 (10)

Job Completion



U 06.04.28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

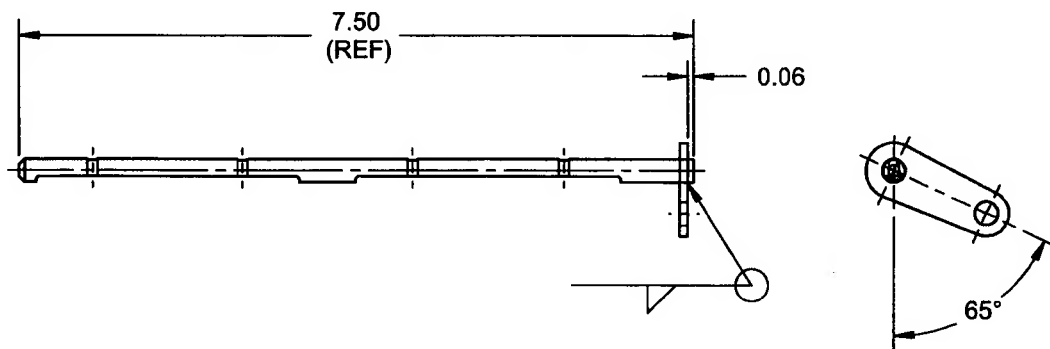
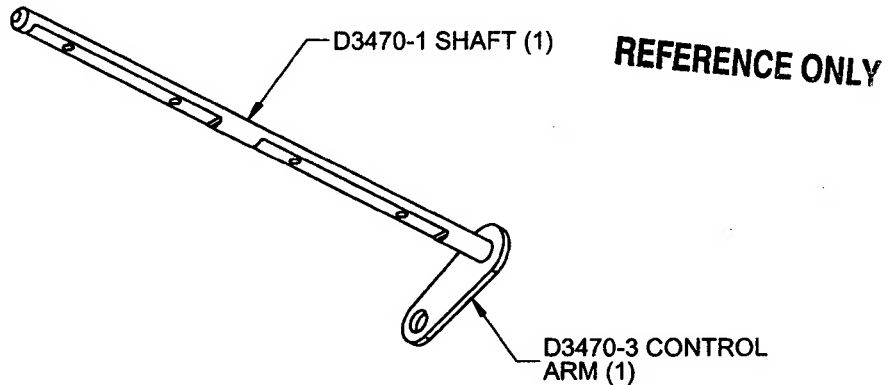
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 9 Date: 06/04/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3470	REV. A SHEET 1 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:2
A	05.12.14	NEW ISSUE	

**D3470-041 SHUT-OFF VALVE SHAFT**

RELEASED
06.04.07 *[Signature]*

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

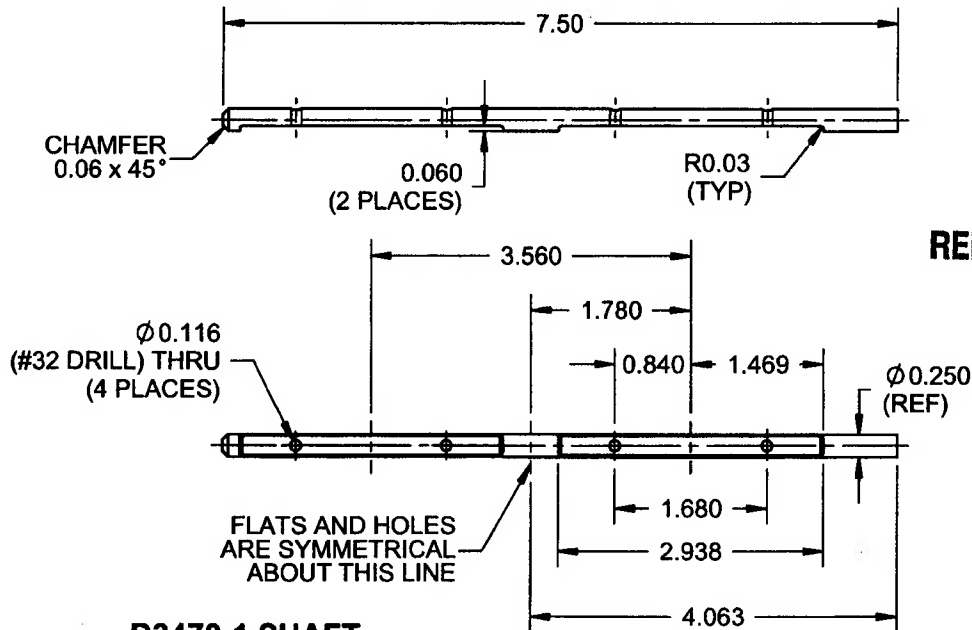
QTY -041	P/N	DESCRIPTION
X	D3470-041	SHUT-OFF VALVE SHAFT
1	D3470-1	SHAFT
1	D3470-3	CONTROL ARM

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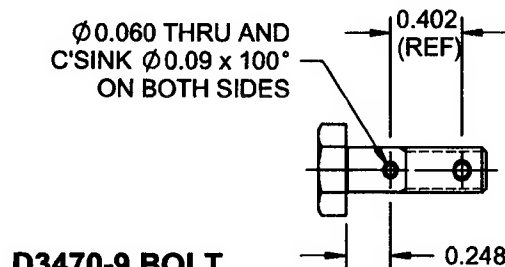
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DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:2

**D3470-1 SHAFT**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR
(REF. DART SPEC. M303R0.250)



- 1) MAKE FROM AN4-6 BOLT

NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

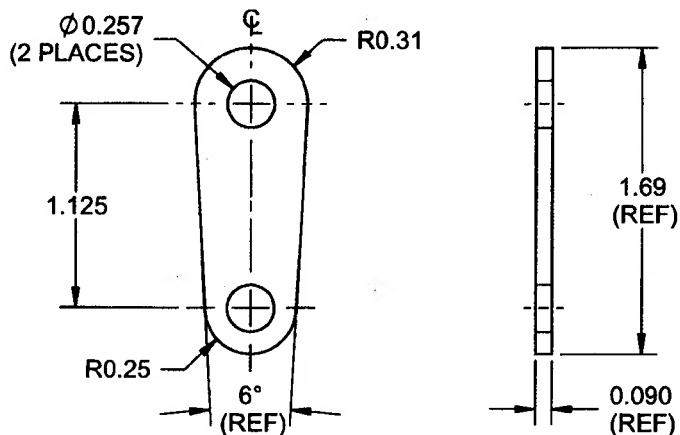
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3470	REV. A SHEET 3 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1

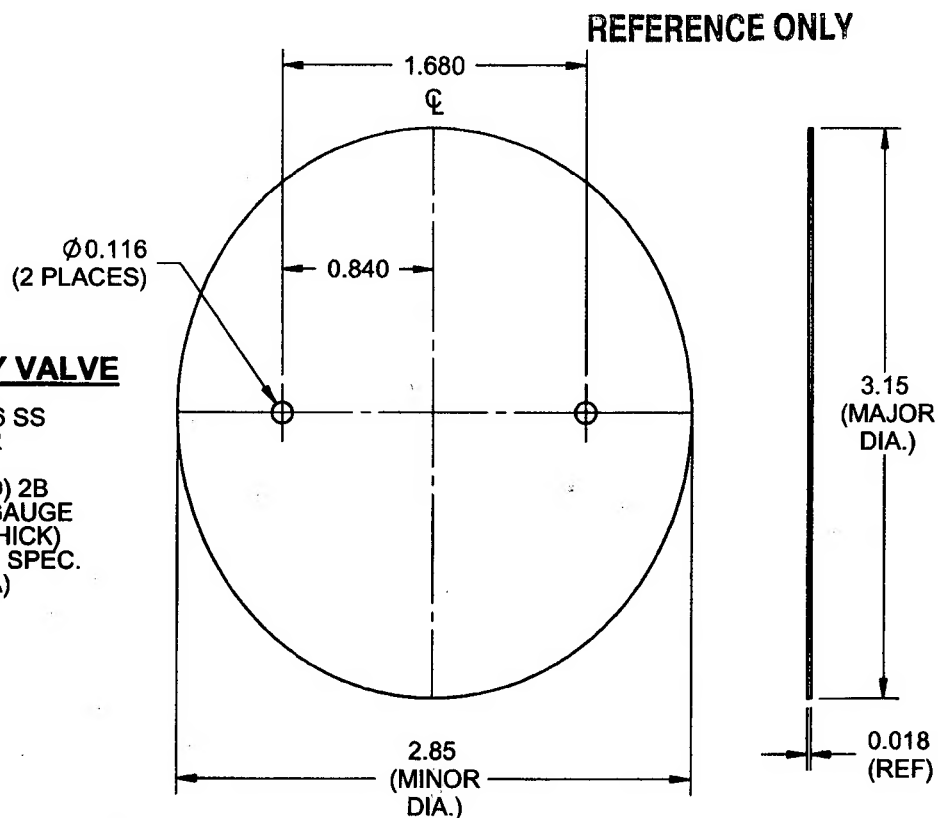
D3470-3 CONTROL ARM

- 1) MATERIAL: AISI 304/316 SS SHEET PER
MIL-S-5019 (ANNEALED) 2B
FINISH 13 GAUGE SS
(0.090 THICK)
(REF. DART SPEC. M304S13GA)



D3470-5 BUTTERFLY VALVE

- 1) MATERIAL: AISI 304/316 SS
SHEET PER
MIL-S-5019
(ANNEALED) 2B
FINISH 26 GAUGE
SS (0.018 THICK)
(REF. DART SPEC.
M304S26GA)



NOTES:

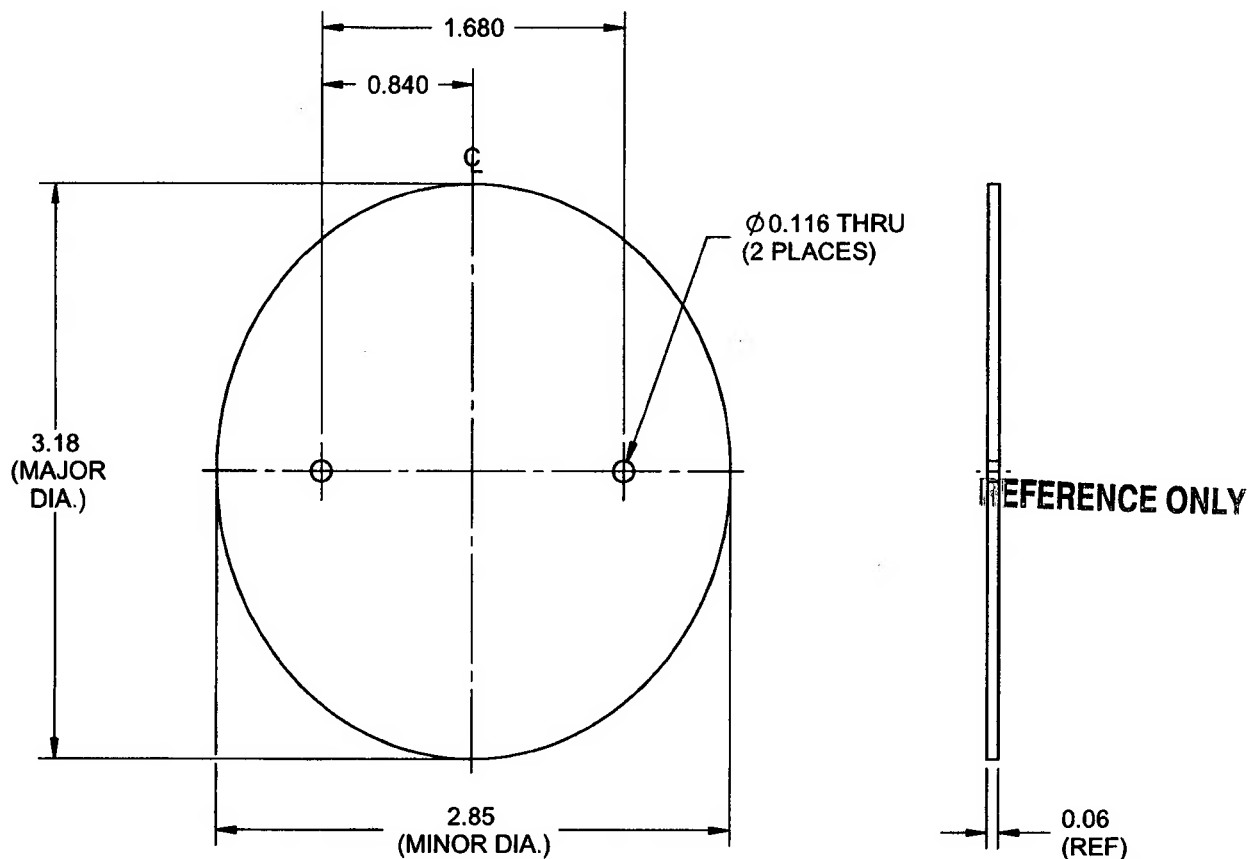
- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1

**D3470-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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